

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2017-28 Date Opened: 06 Feb 17 Title: FabricationAircraft OEM: All Aircraft Model: All Product Type: Handle Product Model: Support/Bushing Quantity: 24**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

N/A
N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
69823	2	Basket Lugs	JC

**Traveller**

Initial or N/A


**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

24
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
JC
N/A
N/A
JC

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: Jeff ClarkeSign: [Signature]SCA: AD02Date: 06-Feb-17

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: [Signature]SCA: AD02Date: 06-Feb-17

Work Order closed by:

Print: Jeff ClarkeSign: [Signature]SCA: AD02Date: 07-Feb-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

## LUG FABRICATION - 69823

### General

These instructions apply to lug 69823-02. Refer to the following drawings, at the current revision, for dimensions and details:

69823, Revision 1 – Lug Fabrication

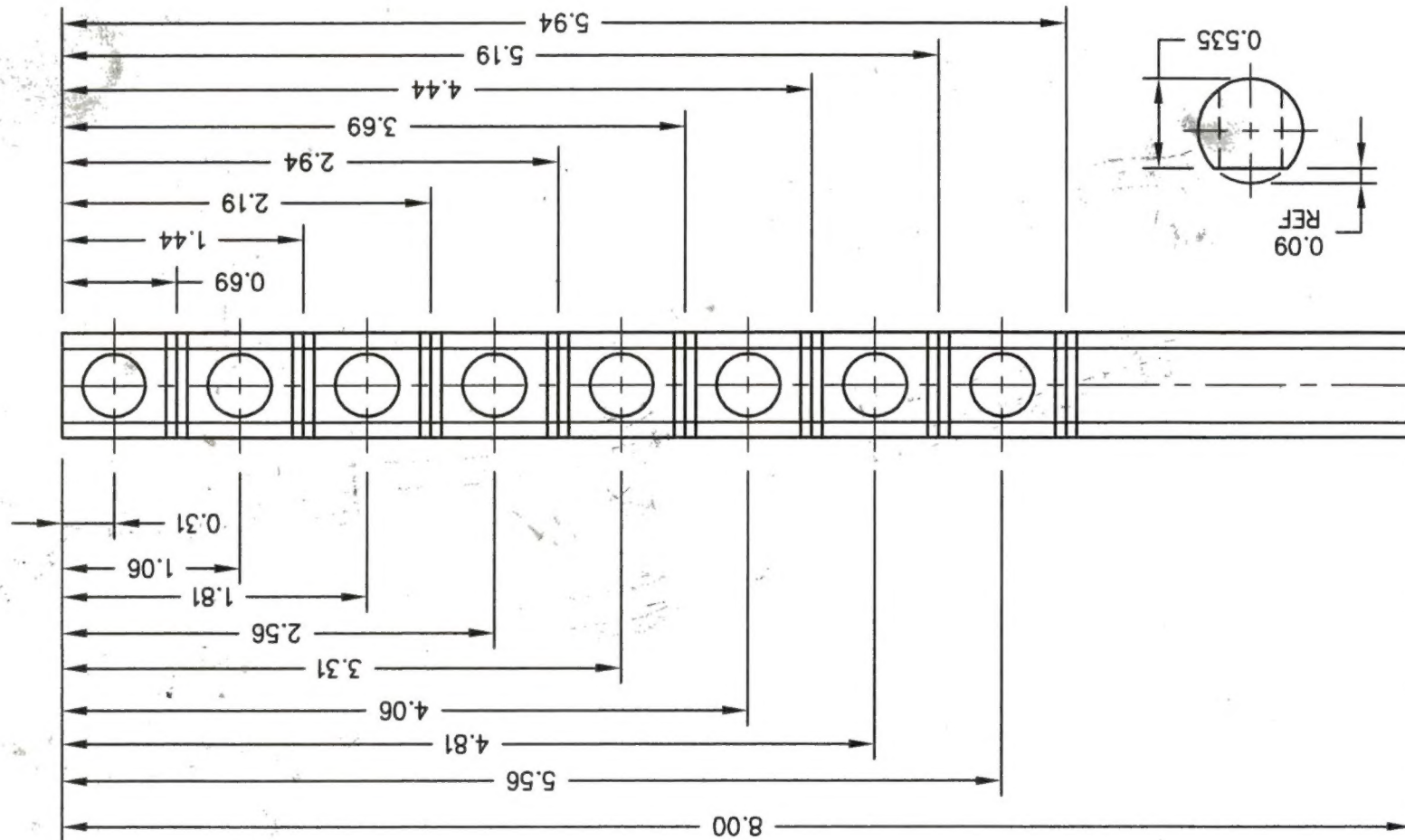
Work Order: 2017-28

Complete  
(initial or SCA #)

Date Open: 06 FEB 2017

AD02

1. Lug Fabrication – 69823-02 (manual production)
  - a. Cut 5/8" round 1018 mild steel material to 8".
  - b. Record material PO on attached material list. PO 15039
  - c. De-burr cut ends using buffing wheel.
  - d. On manual mill, install drill chuck.
  - e. Align end of stock with edge of vise. Set X 0 at this edge.
  - f. Find centre of stock by touching off on both sides. Set Y 0 at centre of stock.
  - g. Using #3 (1/4") or #4 (5/16") centre drill @ 500 RPM:
    - i. Drill onto taper of centre drill at hole locations specified on drawing.
    - ii. Mark cut locations with a small dot, about 0.010" deep, as specified on drawing.
  - h. Using #9 (0.196") drill bit @ 500 RPM, drill through stock at hole locations specified on drawing.
  - i. Using Q (0.323") drill bit @ 250 RPM, drill through stock at hole location specified on drawing.
  - j. Install tapping head, with 3/8-24 tap @ 90 RPM. Set depth to tap through stock, about 1/8" past bottom.
  - k. Tap hole locations as specified on drawing.
  - l. Install collet chuck.
  - m. Using #7 centre drill (5/8") @ 500 RPM, deburr holes.
  - n. Flip bar, insert 3/8-24 bolt without head into threaded hole. Grip bolt with collet or drill chuck to ensure alignment.
  - o. Using a 5/8" end mill @ 750 RPM (or larger end mill), mill 0.09" off height.
  - p. De-burr holes. De-burr edge on buffing wheel.
  - q. Inspect lugs for conformity to drawing.
  - r. Tag complete and inspected lugs and place into stock.



Stop @ 1.0  
9/14

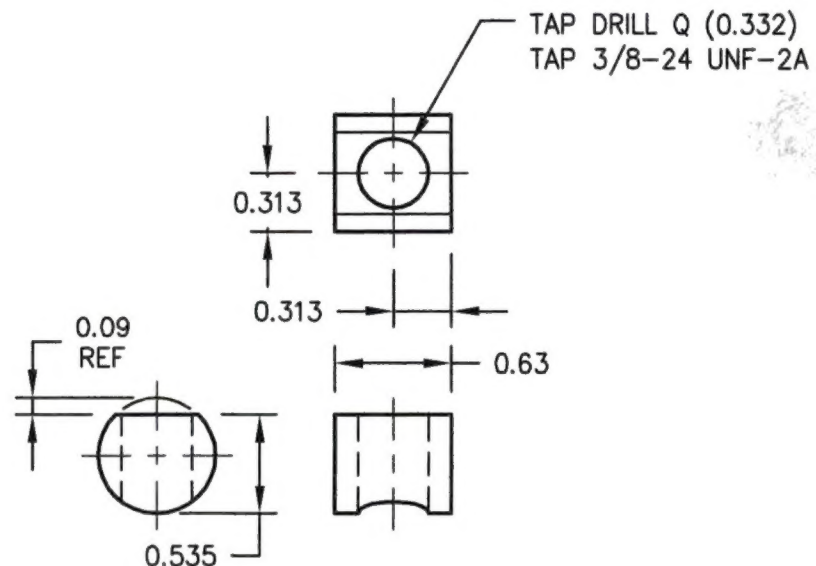


2017-28


REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	REMOVE LUG (ITEM 1)	BJC	27/02/2007
2	TITLE BLOCK UPDATED; SHEET RESIZED; NOTES ADDED	BJC	22/05/2014

## NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.



② LUG

69823-02	02	LUG	1018 MILD STEEL	AISI 1010/1020	5/8 DIA ROD
	01				
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS				
APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGAIN		DATE 10 APR 2006	 <b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2376      www.aerodesign.ca		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS      ANGLES X.XXX ±0.010      ±1/2° X.XX ±0.03 X.X ±0.1		HELICOPTER CARGO BASKET BASKET COMPONENTS - LUGS			
SCALE 1 : 1 SHEET 1 OF 1		DWG. SIZE <b>A4</b>	DWG. NO. <b>69823</b>	REV. <b>2</b>	

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